

65/03

DART AEROSPACE LTD	Work Order:	22077
Description: Doubler	Part Number:	D3208-9
Dwg: D3208 Rev. A1	Qty:	20 20
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: To be made in multiples of 10 Dwg not required	JA	04.12.08	4
2	MV	Cut blank: 4.155" x 4.560" Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3208-9 Batch: M13886 M14646	SD G	04/12/08	20
3	MV	Machine D3208-9 as per Folio FA397 and Dwg D3208 Stack of 10 Identify as D3208-9	SD	05.01.19	20
4	QC2	Inspect parts as they come off the CNC machine	SD	05.01.19	20
5	QC8	Second check	EL	05.01.19	20
6	GA	Deburr Stack	SB	05/01/24	20
7	QC5	Inspect work to Step 6	JA	05.01.24	20
8	FP	Chemical Conversion Coat as per QSI 005 4.1	JA	05-01-24	20
9	QC3	Inspect Chemical conversion Coat	ML	05.01.25	20
10	ST	Identify and Stock	JA	05-01-25	20
11	AC	Cost / part 8.78	545	05-01-26	20
12	DC	Close W/O 8.78 Inspect Level 21	JA	05.01.27	20

Rev	Date	Change	Revised By	Approved
A	04.06.09	New issue	KJ/RF	RF

RELEASED

RF 04.06.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 06, 2004
11:09 am

Work Order No : 0022077
Project Name : D3208-9
Project For : WK503
Work Order Type : Main
Main WO Number :
House Part Number : D3208-9
Description : Doubler
Manufactured : Yes
Amount Req'd : 4
Amount Done : 0
Start Date : 12-06-04
Est Finish Date : 01-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

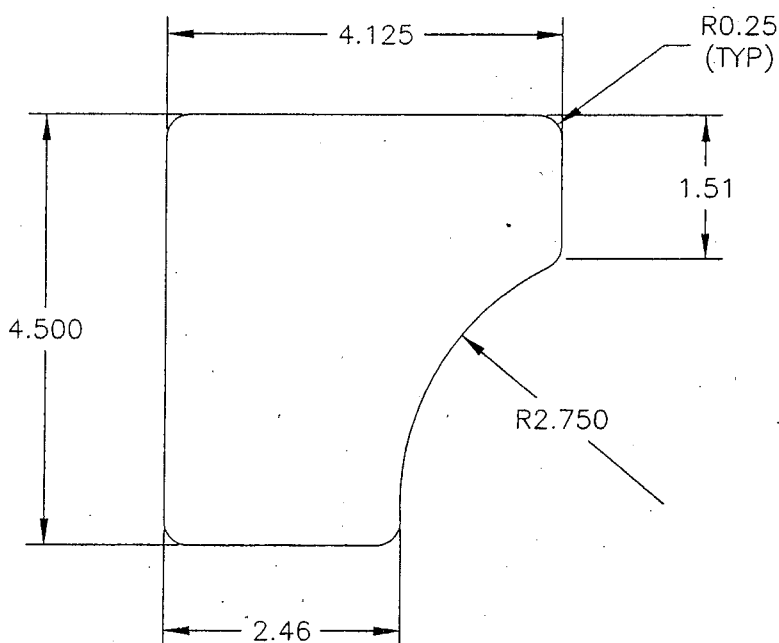
	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART
CONTROLLED COPY



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3208	REV. A SHEET 3 OF 3
DATE 04.01.27		TITLE DOUBLER	SCALE 1:2

RELEASED
[Stamp]



D3208-9 DOUBLER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT
WITHOUT

WORK ORDER
NO. 22077

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DART AEROSPACE LTD		Work Order:	22077
Description: Doubler		Part Number:	D3208-9
Inspection Dwg: D3208 Rev: A			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

1

Prototype

[illegible]

Measured by:	sb	Audited by:	BE	Prototype Approval:	N/A
Date:	05.01.19	Date:	05.01.19	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	